

# Work Order ID 50234

July 14, 2009 10:30:15 AM



Page 1

Item ID: D2174-1

Accept



Setup Start



Revision ID: E

Stop



Item Name: Web

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *09-07-15*, Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2174

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2174 ☐ Dwg Rev: *E* ☐ Prog Rev: *E* 12-

Deburr if necessary

*IB 9-7-22*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*IB 9-7-22*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*=> 5 07/07/22*



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

• **NOTE:** Date & initial all entries

# Work Order ID 50234

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Page 2

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Stop



Item Name: Web

Start Date: 7/15/09

Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur Stack

u/a S

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ S 09/14/22

(x16) φ

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

(16X) m-l 09/01/22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

• **NOTE:** Date & initial all entries

# Work Order ID 50234

July 14, 2009 10:30:15 AM



Page 3

Item ID: D2174-1

Accept



Setup Start



Revision ID: E

Stop



Item Name: Web

Start Date: 7/15/09

Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-22.

16.

170

Identify as per dwg & Stock Location: Sylio

0.00



Packaging

Memo

0.00

Packaging

9/7/08

1100

89

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/23

MF 09-07-23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

• **NOTE:** Date & initial all entries

# Picklist Print

July 14, 2009 10:30:14 AM

Work Order ID: 50234



Parent Item: D2174-1RevE



Parent Item Name: Web

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M2024T3S.063                    |                        | Purchased     | No          |                     |                  | 100             | sf                 | 163.2716       | 4.9705                   |               |                |        |



2024-T3 .063 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

163.2715789

102942

1.5

105916

3.69

106223

1.47

109463

24.2

110980

15.45

111787

114.961579

19059

2

111787

13 9-7-02

16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|                              |               |                             |
|------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 50234    |
| <b>Description:</b> Web      |               | <b>Part Number:</b> D2174-1 |
| <b>Inspection Dwg:</b> D2174 | <b>Rev:</b> E | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

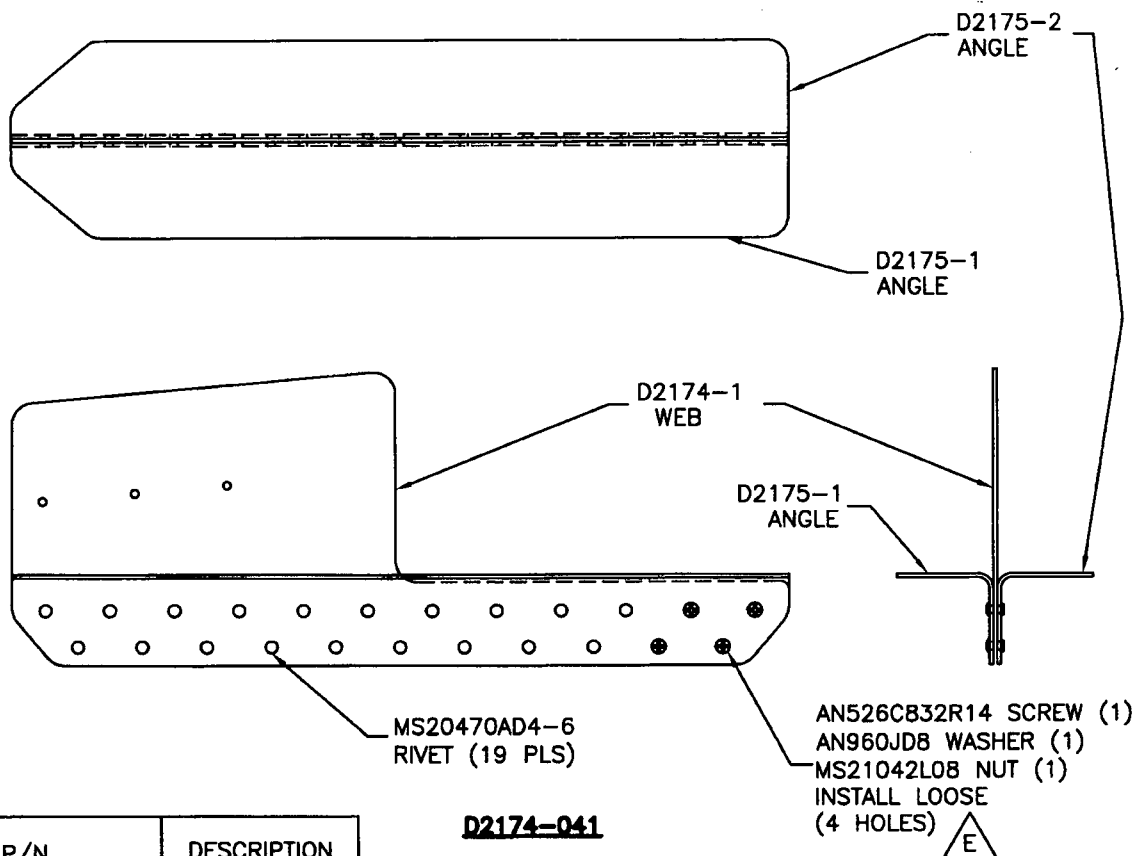
| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 6.250             | +/-0.010      | 6.253            | X      |        |                      |          |
| 6.400             | +/-0.010      | 6.400            | X      |        |                      |          |
| 4.800             | +/-0.010      | 4.806            | X      |        |                      |          |
| 1.375             | +/-0.010      | 1.376            | X      |        |                      |          |
| 1.050             | +/-0.005      | 1.050            | X      |        |                      |          |
| Ø0.128            | +0.005/-0.001 | .130             | X      |        |                      |          |
| 12.650            | +/-0.010      | 12.650           | X      |        |                      |          |
| 0.550             | +/-0.010      | .550             | X      |        |                      |          |
| 0.900             | +/-0.010      | .901             | X      |        |                      |          |
| 1.629             | +/-0.010      | 1.629            | X      |        |                      |          |
| 1.506             | +/-0.005      | 1.506            | X      |        |                      |          |
| 11.550            | +/-0.005      | 11.550           | X      |        |                      |          |
| 50°               | +/-0.5°       | 50°              | X      |        |                      |          |
| 0.063 thick       | +/-0.010      | .064             | X      |        |                      |          |
| Ø0.172            | +0.005/-0.001 | .175             | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                       |                            |     |
|------------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> RB | <b>Audited by:</b> S  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 9-7-22    | <b>Date:</b> 09/07/22 | <b>Date:</b>               | N/A |

| Rev | Date     | Change                 | Revised by | Approved |
|-----|----------|------------------------|------------|----------|
| A   | 04.08.12 | New Issue              | KJ/JLM     |          |
| B   | 07.04.02 | Ø0.172 dimension added | KJ/JLM     |          |

**DART**

| DESIGN           | DRAWN BY       | DART AEROSPACE LTD                  |              |
|------------------|----------------|-------------------------------------|--------------|
| RF               | CE             | HAMKESBURY, ONTARIO, CANADA         |              |
| CHECKED<br>PH    | APPROVED<br>CE | DRAWING NO.                         | REV. E       |
| DATE<br>06.09.25 |                | D2174                               | SHEET 1 OF 2 |
|                  |                | TITLE                               | SCALE        |
|                  |                | WEB ASSEMBLY                        | 1:3          |
| A                | 95.10.25       | NEW ISSUE                           |              |
| B                | 96.01.18       | RE-DRAWN                            |              |
| C                | 00.09.11       | UPDATE FINISH SPEC.                 |              |
| D                | 04.06.03       | RE-DESIGN                           |              |
| E                | 06.09.25       | INC 4 HOLES TO Ø0.172; CHG HARDWARE |              |



**D2174-041**

| QTY<br>-041 | P/N          | DESCRIPTION  |
|-------------|--------------|--------------|
| X           | D2174-041    | WEB ASSEMBLY |
| 1           | D2174-1      | WEB          |
| 1           | D2175-2      | ANGLE        |
| 1           | D2175-1      | ANGLE        |
| 4           | AN526C832R14 | SCREW        |
| 4           | AN960JD8     | WASHER       |
| 4           | MS21042L08   | NUT          |
| 19          | MS20470AD4-6 | RIVET        |

**NOTES:**

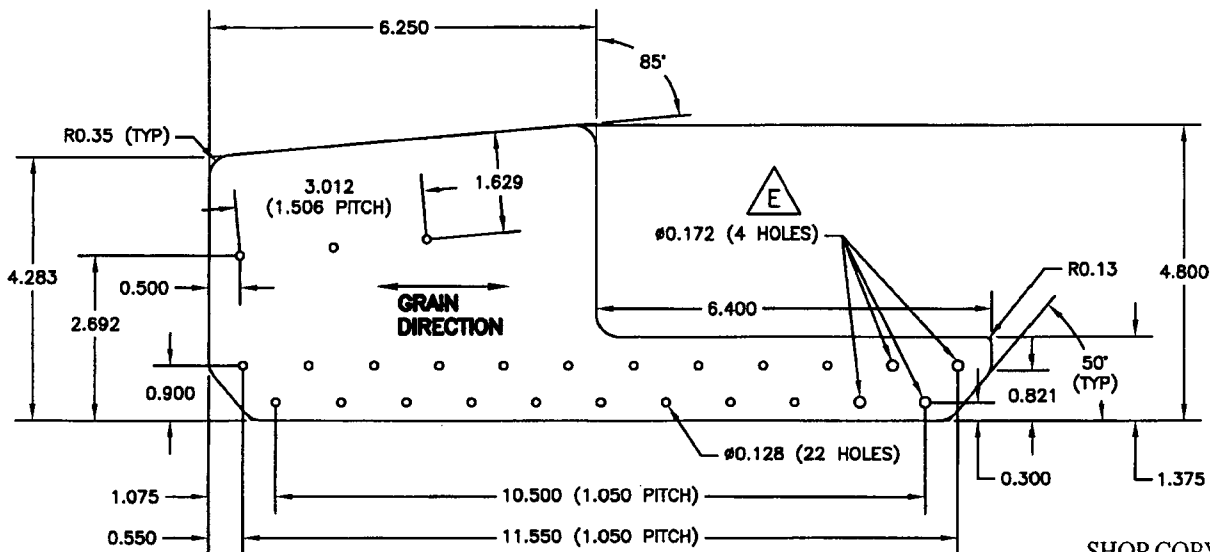
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50234  
MF 09-07-15

**RELEASED**  
06.10.13

**DART**

|         |          |          |       |                             |        |
|---------|----------|----------|-------|-----------------------------|--------|
| DESIGN  | RF       | DRAWN BY | CE    | DART AEROSPACE LTD          | REV. E |
| CHECKED | PH       | APPROVED | PH    | HAWKESBURY, ONTARIO, CANADA |        |
| DATE    | 06.09.25 | TITLE    | D2174 | SHEET 2 OF 2                |        |
|         |          | WEB      |       | SCALE                       | 1:3    |



**D2174-1**

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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50234

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

**RELEASED**  
06.10.23

MF  
09-07-15